

# Work Order ID 73081

Thursday, August 25, 2011 1:57:38 PM



Page 1

Item ID: D350-602-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Pod, LH

Start Date: 8/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00



Customer:

Reference: **REWORK**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2694

I

DSI 9515

B

**A D220Z Rev. G P 11.08.31**

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-602-013

CHG002

**2 11/09/13**

**for BG 11-9-13**

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ONT. CANADA K6A 1K7				TO APPROVAL #09-89 TEL: 1-613-632-5200	
PN	D350-602-011	CHG	CHG006		
DESC.	Heli-Utility-Pod	SIC	SH93-97		
LOT	B61171	SIC	SR01144NY		
MODEL	AS350	SIC			
MADE IN CANADA					
D2729-1					

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Page 2

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

0.00



Small Fab

Small Fab

Memo

0.00

PULL FROM STOCK:

1 X D350-602-011 B

MODIFY PER DEO 9217

1-Assemble as per Dwg D2694

2-Install label D2258-160 on Pod Assembly as per Dwg D2694 at location of  
max pod load label on pg2  
of dwg

3-MODIFY AS PER DEO 9217

INSTALL 1 X D3048-1 B

W/40X AD64ABS B

EPOCAST 50A/B B

HARDENER 9816 B

90Z CLOTH B

PRIMER FILLER B

ACTIVATOR B

RTV SEALANT B

ET 11-09-08



W/O: 173081		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11-09-12	140	install AD66 ABS rivets in proper location as per Dwg D2202 Rev 1 AD66 ABS <u>B112787</u> x2	ET	11-09-12	1	W 11/09/13	M 11/09/13	
11-09-12	140	removed lid on pod to make it easier to modify the pod reinstall lid as per Dwg D2694 + replace drilled out rivets AD62 ABS x19 <u>B 116053</u>	ET	11-09-12	1	W 11/09/13	M 11/09/13	

Part No: D350-602-013 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73081**

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Page 3

Item ID: D350-602-013

Accept

Setup Start

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Item Name: Heli-Utility-Pod, LH

Start Date: 8/25/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11.09.13 (1)

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

ENSURE ORIGINAL KIT IS PACKAGED IN BOX

11/9/13 (1)

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/16/13

(1)

**Work Order ID 73081**

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Page 4

Item ID: D350-602-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Utility-Pod, LH

Start Date: 8/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

REPACKAGE PER PPP D350-602-013  
USING NEW B/N  
NEW LABELS REQUIRED  
Identify and pack for shipping as per PPP D350-602-013  
Location: \_\_\_\_\_  
PPP Rev: \_\_\_\_\_

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

P-11/9/13 (1)

11/9/14

MF  
11-09-13

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Page 1

**Parent Item:** D350-602-013

**Parent Item Name:** Heli-Utility-Pod, LH




**Start Date:** 8/25/2011

**Required Date:** 9/2/2011

**Start Qty: 1.00**

**Required Qty: 1.00**

**Comments:** IPP Rev:A New Issue 06-05-01 JLM IPP Rev:B Added D3495-1 06-05-17  
JLM IPP RevC: add route seq DD 10.01.07 verified  
by:EC IPP REV:D AS PER ECN 10-558 JLM 10-04-27  
VERIFIED BY:DD  
IPP Rev:C 09-02-03 update dwg rev's DD verified by:EC IPP Rev:D  
add D2202-1 and D2202-5 DD 10.04.07 verified:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AD64ABS 		Purchased	No				Each	300.0000		<del>442</del>	200	02202	Rev C
Pop Rivets										11-09-12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST281				300					
					108712			100		X42			
					116166			200					
D3048-1 		Manufactured	No				Each	3.0000		1			
Doubler										85		11-09-08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST139				3					
					52223			3					
D350-602-011 		Manufactured	No				Each	3.0000		1			
Heli-Utility-Rod (LH/RH)										85		11-09-08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG104				3					
					52427			1					
					61171			1		X1			
					63355			1					

# Picklist Print

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Page 2

Work Order ID: 73081

Parent Item: D350-602-013

Parent Item Name: Heli-Utility-Pod, LH



Start Date: 8/25/2011

Required Date: 9/2/2011

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

sf

2,349.811

2



7781 9oz Glass 50"x125yd

85 11-09-08

## Location

## Loc Qty

## Loc Code

CA

1373.811

117602

1373.811

x2

ST404

976

104845

3

108932

18

111166

392

113905

563

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Shop Packet Print

Page 2

Qty	Part Number	Description
X	D2694	UTILITY POD ASSEMBLY
1	D2202-1	POD LID
1	D2202-3	POD BASE
5	D2204-9	LATCH
1	D2429-041	SPRING CLIP ASSEMBLY
1	D2461-1700	NEOPRENE SEAL
5	D2528-1	BACKER PLATE
4	D2528-3	BACKER PLATE
1	D2569	HINGE
1	D3007-041	PROP ASSEMBLY
19	AN4-5A	BOLT
1	AN4-6A	BOLT
2	AN526C632R7	SCREW
21	AN960JD416	WASHER
2	AN960JD6	WASHER
2	MS21042L06	NUT (OR MS21042-06)
20	MS21042L4	NUT (OR MS21042-4)
38	AD62ABS	RIVET

# **GENERAL NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: PRIME AND PAINT PER QSI 005 4.2 TO MATCH ORIGINAL FINISH  
AS REQ'D TO TOUCH UP FINISH AFTER DRILLING OR ASSEMBLY  
INSIDE: DUPONT HIGHBUILD PRIMER GREY 1144-S  
OR DUPONT 2K-URETHANE PRIMER GREY 7704-S  
OUTSIDE: DUPONT IMRON POLYURETHANE ENAMEL BASE WHITE (555U)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 48.5 lbs
- 8) TRANSFER DRILL UNSPECIFIED HOLES FROM ATTACHING PART AS FOLLOWS: AN526C632 → DRILL Ø0.141  
AN4 → DRILL Ø0.257
- 9) SEAL ALL HOLES AND EDGES OF POD WITH CYANOACRYLATE GLUE
- 10) FOR D2569 HINGE:
  - (i) INSTALL RIVET HEADS FROM OUTSIDE OF POD
  - (ii) GRIND TRAILING EDGE OF RIVET TO PERMIT HINGE TO CLOSE
  - (iii) ENSURE ALL RIVET HOLES ARE DRILLED ON THE LARGER HINGE TABS AS SHOWN IN DETAIL A

**RELEASED**  
2010-04-29

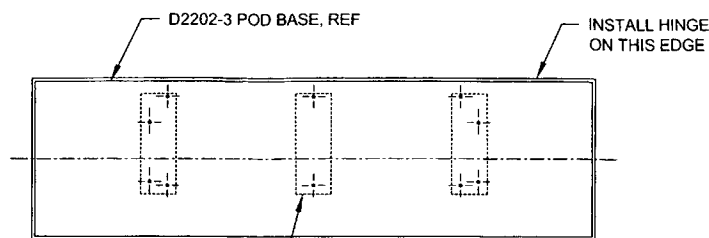
I	REFORMAT, D2204-9 LOC SPEC'D (B2-4.86-4,C2-4,C6-4,B6-5,C6-5), D2461-X WAS D2462-X (D5-1,B1-2), ADD FINISH (B5-1)	CP	10.04.20
H	CHANGED RIVETS FROM AD64ABS TO AD62ABS (PAR#185)	DC	07.07.18
G	REVERT BACK TO D2204-9 LATCH	CP	01.05.08
F	REDESIGN, CHANGE LATCHES & PROP	CP	01.03.20
E	CHANGE DIMENSIONS	RF	99.12.20
D	SEAL & HINGE CHANGE (TSR A1047 & A855/A858); INCLUDED DE09119	CP	99.01.08
C	ADD DOUBLER HOLES, REMOVE FINISH	KE	98.11.12
B	CHANGE RIVET PATTERN, ADD D2429	KE	97.10.08
A	NEW ISSUE CREATED TO REPLACE D350-602-041 AND -043	KE	97.07.02
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. I D2694 SHEET 1 OF 5 TITLE SCALE UTILITY POD ASSEMBLY NTS COPYRIGHT © 1997 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.20		



8 7 6 5 4 3 2 1

D

D

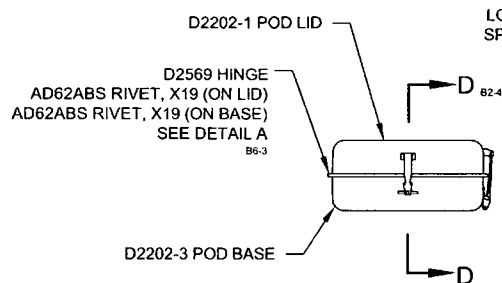


NOTE ORIENTATION OF DOUBLERS IN POD BASE

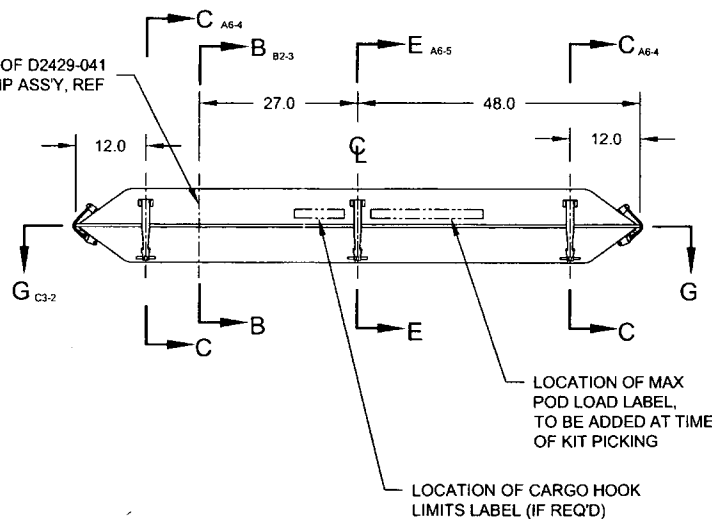
SECTION G-G B6-2

C

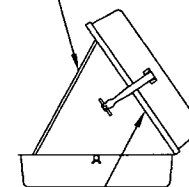
C



LOCATION OF D2429-041 SPRING CLIP ASS'Y, REF



D3007-041 PROP ASS'Y, SEE SECTION E & F A6-5, B5-5



D2461-1700 NEOPRENE SEAL, INSTALL ALONG TOP INSIDE EDGE OF LID (USE CONTACT CEMENT)



B

B

A

A

D2694 UTILITY POD ASSEMBLY

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2010-04-29

DESIGN	JB	DART AEROSPACE LTD	
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MFG. APPR.	JP	D2694	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD ASSEMBLY	NT
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D

C

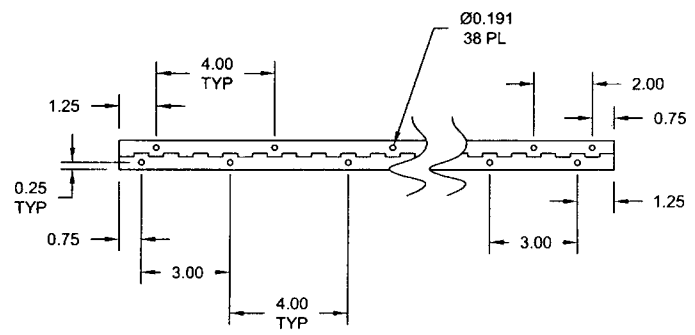
C

B

B

A

A



DETAIL A: HINGE  
NOT TO SCALE

10  
C7-2

D2429-041  
SPRING CLIP ASS'Y

AN526C632R7 SCREW  
AN960JD6 WASHER  
MS21042L06 NUT,  
2 PL SHOWN

8

D2202-1 POD LID, REF

2.7

D2202-3 POD BASE, REF

SECTION B-B  
NOT TO SCALE

C5-2

**RELEASED**  
2010-04-29  
*mp*

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DRAWN	<i>JP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D2694	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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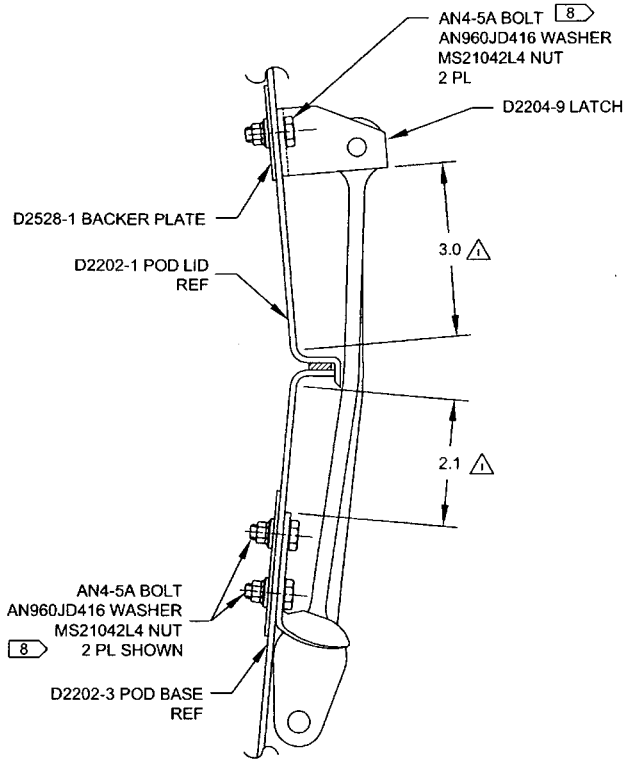
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D

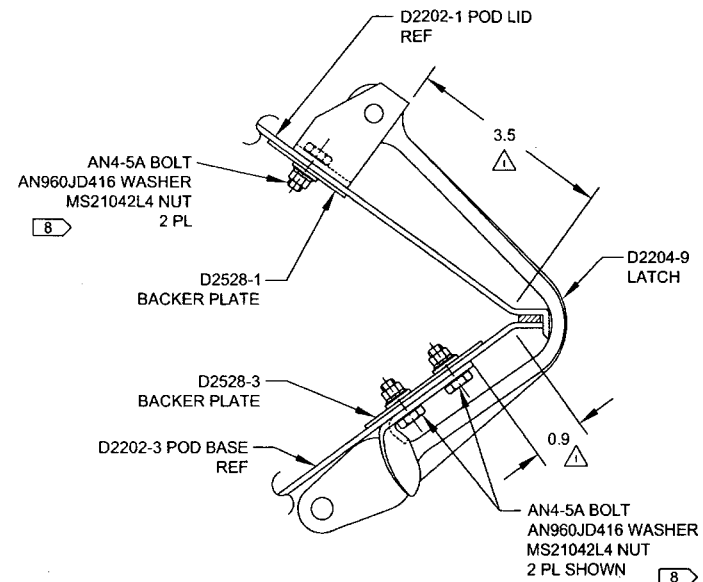
C

B

A



SECTION C-C  
SCALE 10X C3-2, C5-2



SECTION D-D  
SCALE 10X C6-2

RELEASED  
2010-04-29

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DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. I
MFG. APPR.	JP	D2694	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD ASSEMBLY	NTS
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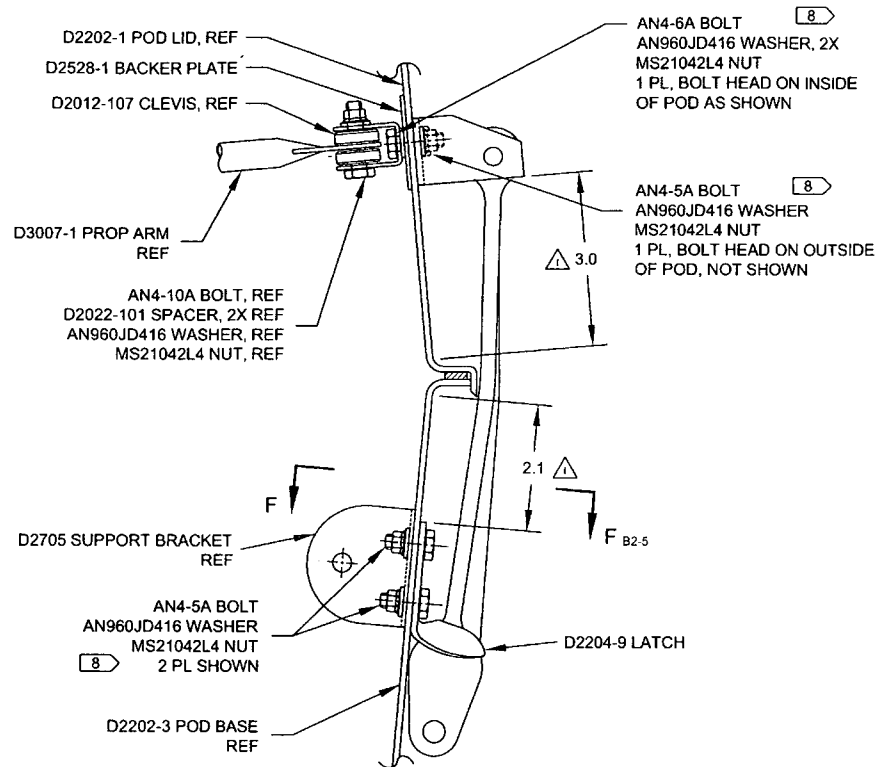
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D

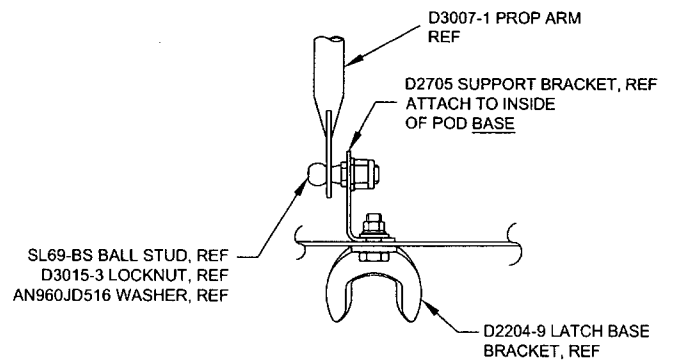
C

B

A



SECTION E-E C4-2  
SCALE 10X



SECTION F-F B5-5  
D3007-041 PROP ASSY DETAIL  
SECTION ROTATED 85° CW

**RELEASED**  
2010-04-29

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D2694	SHEET 5 OF 5
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8 7 6 5 4 3 2 1

**NOTES:**

## 1) MATERIALS:

RESIN: EPOCAST 50-A/9816,  
OR DERAKANE 470-36/411/510A40FOAM: A500 CORE CELL,  
OR DIVINYCELL,  
OR AIREX,  
0.38 THICK (3/8 FOAM)FIBRE: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
5 oz PLAIN WEAVE KEVLAR (5 oz KEVLAR)2) FINISH: INSIDE = PRIME PER DART QSI 005 4.2  
OUTSIDE = WHITE GELCOAT #GEL 944W005

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: N/A

8) LAMINATE PER DART QSI 006.  
LAMINATION SCHEDULE PER THIS DRAWING.

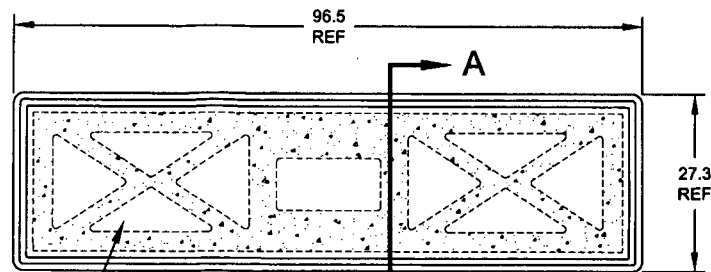
9) PEEL PLY ALL SURFACES.

**RELEASED**  
2010-10-28  
MD

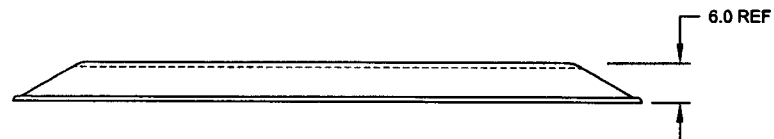
G	REFORMAT DRAWING TO CURRENT STANDARDS; D2202-101 WAS D2202-1 (ZN C5-2, A4-2); ADD 77.5 & 22.0 DIM. (ZN D4-3, C6-3); D2202-103 WAS D2202-5 (ZN C5-3, A4-3); ADD 2.00 MAX (ZN D3-4); INCORPORATED DEO 9217 & ADD D2202-5/-6 ON SHEET 5 PER PAR 09-034		RF	09.10.06
F	CHANGE LAYUP, DOUBLER, NOW DRILLED	CP	01.03.14	
E	ADDED SECTIONS WITH LIP DIMS	KE	99.11.11	
D	MOVED DOUBLERS, REMOVED HOLES	KE	98.11.09	
C	REVISED DOUBLER/HOLES LOCATIONS	KE	97.07.04	
B	ADD DOUBLERS AND HOLES	-	93.10.27	
A	NEW ISSUE	-	93.10.27	
REV.	DESCRIPTION		BY	DATE
DESIGN	KE	<b>DART AEROSPACE LTD</b>		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	99	DRAWING NO.	REV. G	
MFG. APPR.	JM	D2202	SHEET 1 OF 5	
APPROVED	99	TITLE	SCALE	
DE APPR.	99	UTILITY POD LID AND BASE	NTS	
DATE	09.10.06			
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SEE  
DETAIL B  
A6-2

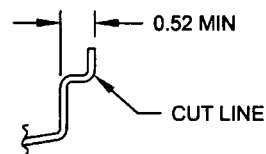
**SECTION A-A** C3-2



**G**  
D2202-101 FOAM CORE,  
MAKE FROM 3/8" FOAM, ROUTER PER DT8024



**D2202-1 LID**  
(MOLD DT8002)



**DETAIL B**  
SCALE 10X D6-2

**MAIN LAYUP**

**G**  
9oz SATIN  
9oz SATIN  
5oz KEVLAR  
D2202-101 FOAM CORE  
5oz KEVLAR  
9oz SATIN

**RELEASED**  
2010-10-28

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 2 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	UTILITY POD LID AND BASE	NTS
DATE	09.10.06	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

D

D

C

C

B

B

A

A

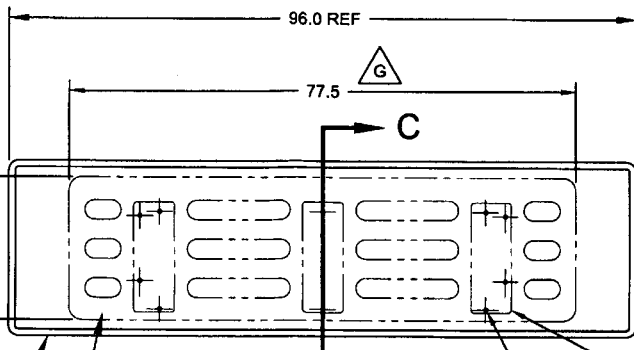
SEE  
DETAIL D  
B7-3

**SECTION C-C** C4-3

ENSURE THIS  
EDGE IS STRAIGHT  
WITHIN 0.060"  
AFTER TRIMMING



22.0

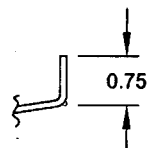


27.0  
REF

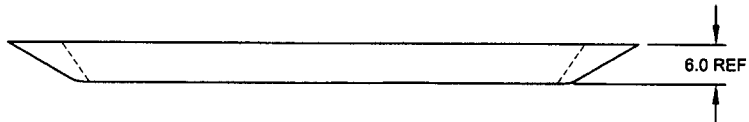
DETAIL E,  
DOUBLER INSTALLATION

DETAIL F,  
HOLE LOCATION

D2202-103 FOAM CORE,  
MAKE FROM 3/8" FOAM, ROUTER PER DT8559



**DETAIL D**  
SCALE 10X D7-3



**D2202-3 BASE**  
(MOLD DT8002)

**MAIN LAYUP**

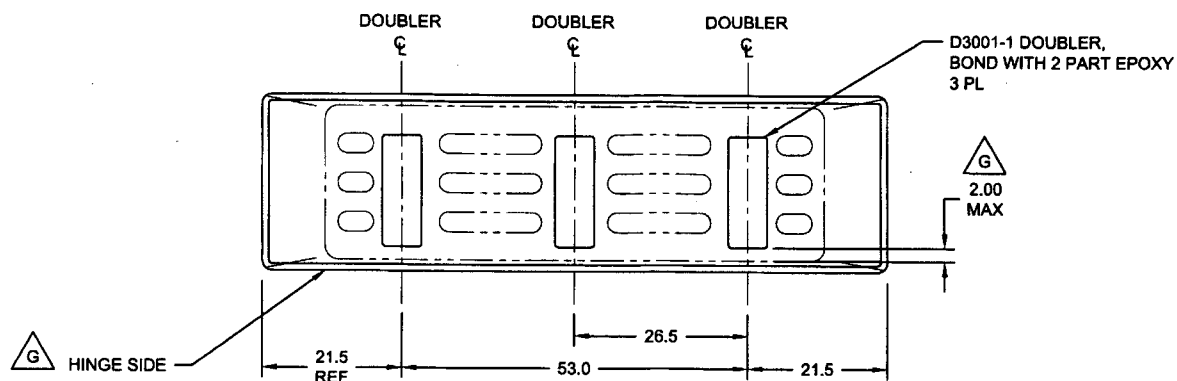
9oz SATIN  
9oz SATIN  
5oz KEVLAR  
D2202-103 FOAM CORE  
5oz KEVLAR  
5oz KEVLAR  
9oz SATIN



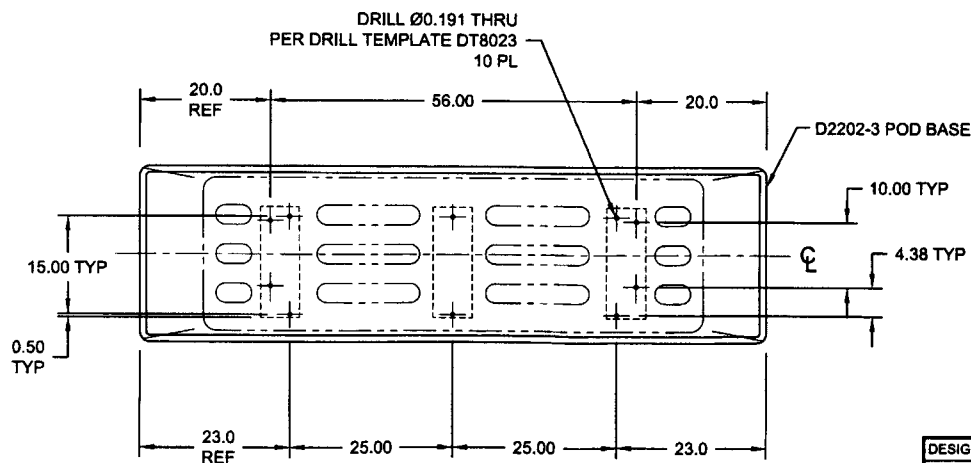
**RELEASED**  
2010-10-28

DESIGN	KE	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. G
MFG. APPR.	JM	D2202	SHEET 3 OF 5
APPROVED	JP	TITLE	SCALE
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8 7 6 5 4 3 2 1



**DETAIL E: INSTALLATION OF D3001-1 DOUBLERS** C3-3



**DETAIL F: HOLE DRILLING** C3-3  
(AFTER DOUBLER INSTALLATION)

**RELEASED**  
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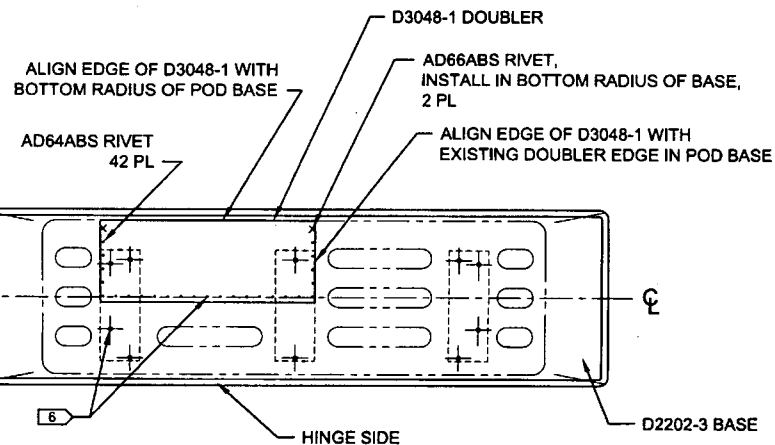


**NOTES : TO MAKE A D2202-5/6 BASE (FOR D350-602-013/-014) FROM A D2202-3 BASE**

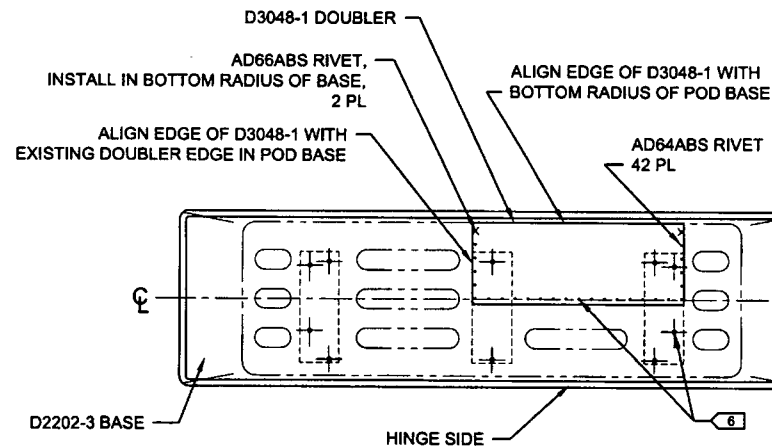
- 1) REMOVE FOAM IN AREA OF POD BASE WHERE D3048-1 DOUBLER WILL BE INSTALLED
- 2) FILL GAPS WITH 9oz SATIN AND RESIN PER DWG (APPROX. 3-4 LAYERS)
- 3) 2 LAYERS OF 9oz SATIN
- 4) BOND D3048-1 DOUBLER IN ORIENTATION SHOWN AND LET CURE
- 5) TRANSFER Ø0.125 HOLES FROM D3048-1 TO POD BASE. INSTALL DOUBLER WITH AD64ABS RIVETS (42) AND AD66ABS (2)
- 6) TRANSFER Ø0.191 HOLES FROM POD BASE TO D3048-1. SEAL HOLES WITH CYANOACRYLATE GLUE
- 7) TOUCH UP AFFECTED AREA WITH GREY PRIMER PER DWG
- 8) FILL CENTER OF THE AD RIVETS WITH RTV 732 TO SEAL

**PART LIST:**

QTY -5	QTY -6	PART NUMBER	DESCRIPTION
X		D2202-5	POD BASE
	X	D2202-6	POD BASE
1	1	D2202-3	BASE
1	1	D3048-1	DOUBLER
42	42	AD64ABS	RIVET
2	2	AD66ABS	RIVET
A/R	A/R	RTV	SEALANT



**D2202-5 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)



**D2202-6 BASE: D3048-1 DOUBLER INSTALLATION**  
(MAKE FROM D2202-3 BASE)

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APPROVED	JP	TITLE	SCALE
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